

Work Order ID 52761

October 14, 2009 9:07:42 AM



Page 1

Item ID: D3953-13

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gas Spring Spacer

Start Date: 14/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 21/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: PT

Date: 9-10-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3953	A								

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3953

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

IB 9-10-22

EP 09/10/27 (40)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 9-10-22

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Page 2

Item ID:	D3953-13	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Gas Spring Spacer					
Start Date:	14/10/2009	Start Qty:	40.00		Cust Item ID:	
Required Date:	21/10/2009	Req'd Qty:	40.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	S 02/10/02			Control (+40)	/		
130 Small Fab Small Fab	Memo 1- OPEN HOLES AS PER DWG 2- DEBURR IF NECESSARY	0.00 0.00	u / a						
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	S 02/10/02			(+40)	/		

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Page 3

Item ID: D3953-13

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gas Spring Spacer

Start Date: 14/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 21/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 139

0.00



Packaging

Memo

0.00

Packaging

09/10/28 (90)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/04

u 09/11/04

Picklist Print

October 14, 2009 9:07:48 AM

Fantabutose

Page 1

Work Order ID: 52761



Parent Item: D3953-13



Parent Item Name: Gas Spring Spacer

Start Date: 14/10/2009

Required Date: 21/10/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B0.625X3.000		Purchased	No			100	f	26.1166	1.3158			
304 BAR .625 X 3.00												

B941077

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

26.1166

112320

13.1

112442

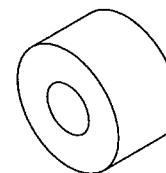
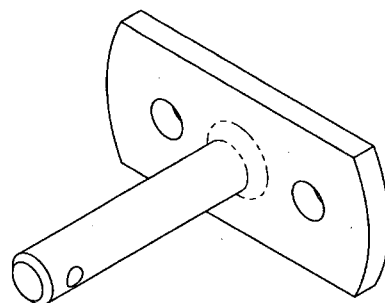
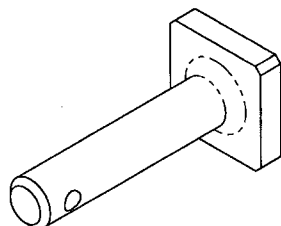
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107979

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WORK ORDER
NO. 32741
09-10-151



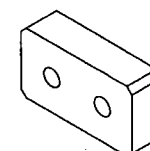
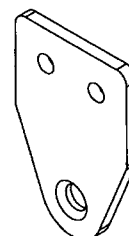
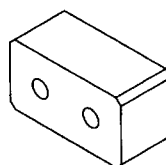
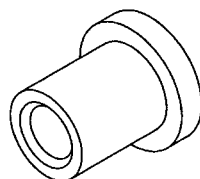
D3953-1 GAS SPRING BRACKET
(FULL LID)

D3953-3 GAS SPRING STUD, LID

D3953-5 GAS SPRING STUD, BASE

D3953-7 GAS SPRING SPACER

D3953-9 GAS SPRING WASHER



D3953-11 GAS SPRING SPACER

D3953-13 GAS SPRING SPACER
(FULL LID)

D3953-15 GAS SPRING BRACKET
(SPLIT LID)

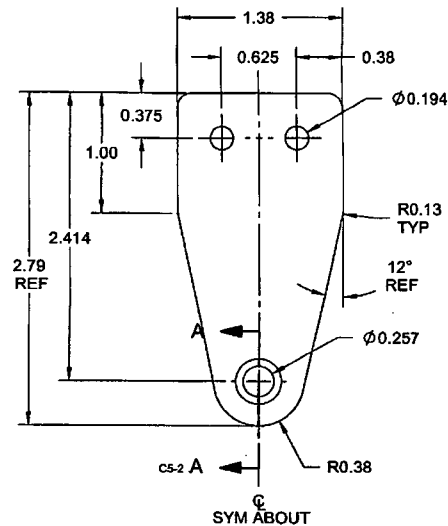
D3953-17 GAS SPRING SPACER
(SPLIT LID)

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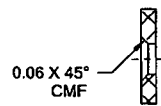
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
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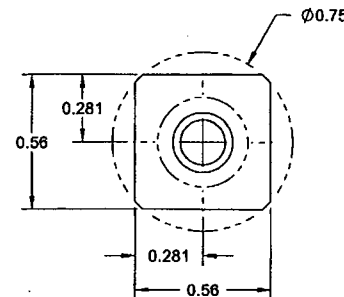
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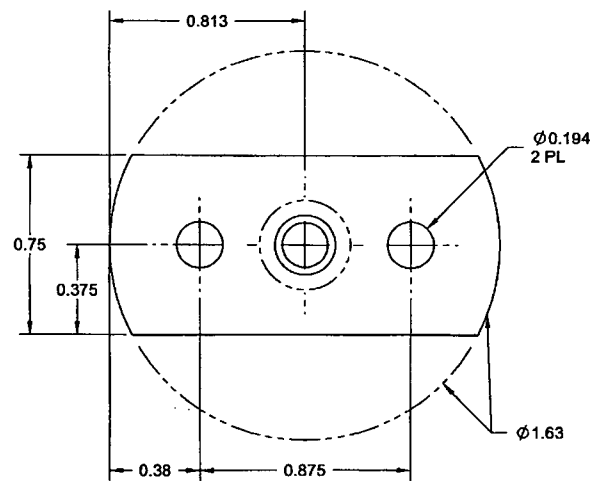
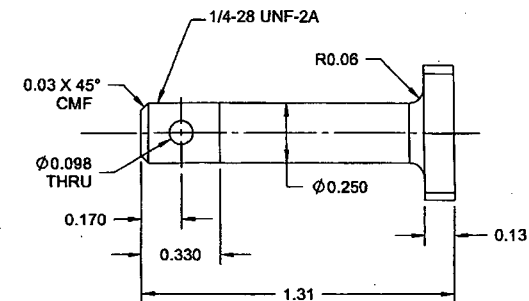
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 (FULL LID)



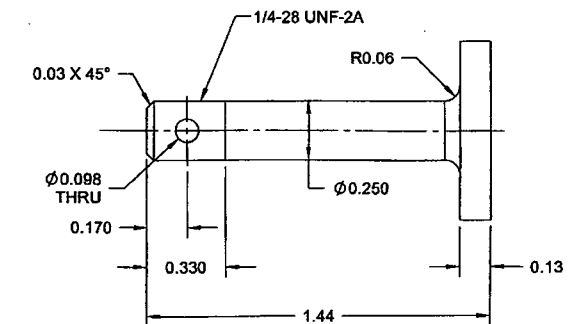
SECTION A-A C7-2



D3953-3 GAS SPRING STUD, LID



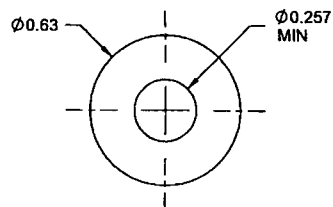
D3953-5 GAS SPRING STUD, BASE



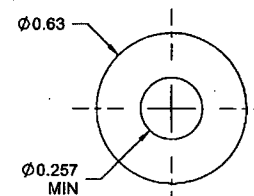
- NOTES:
 1) MATERIAL -1: MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK
 REF DART SPEC M304S
 -3 & -5: AISI 304 STAINLESS STEEL BAR
 REF DART SPEC M304B
 OR: AISI 304/316 STAINLESS STEEL ROD
 REF DART SPEC M304R
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT -1: 0.11 lbs
 -3: 0.03 lbs
 -5: 0.06 lbs

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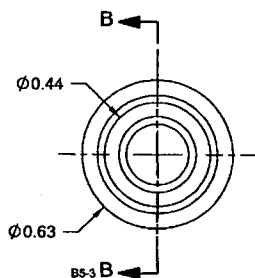
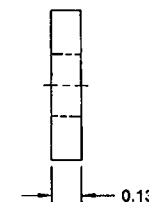
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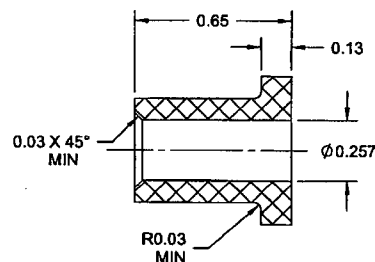
D3953-7 GAS SPRING SPACER



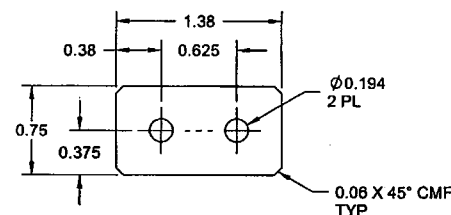
D3953-9 GAS SPRING WASHER



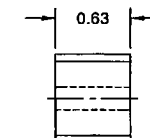
D3953-11 GAS SPRING SPACER



SECTION B-B B7-3



D3953-13 GAS SPRING SPACER



NOTES:

1) MATERIAL -7, -9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

-13: 0.17 lbs

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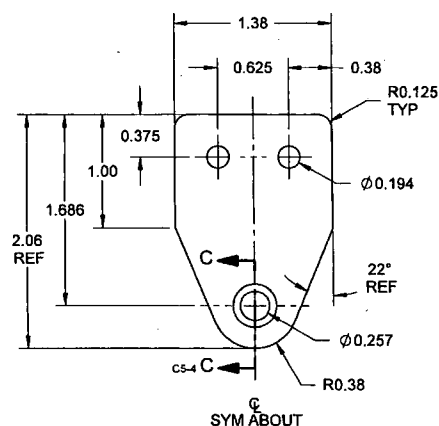
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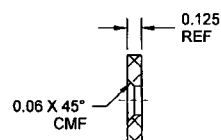
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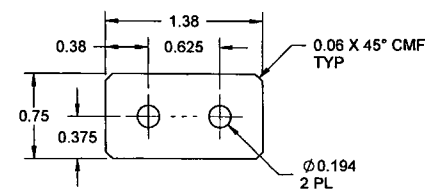
NO. 52791



D3953-15 GAS SPRING BRACKET
(SPLIT LID)



SECTION C-C C7-4



D3953-17 GAS SPRING SPACER
(SPLIT LID)

NOTES:

1) MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK
REF DART SPEC M304S

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -15: 0.08 lbs

-17: 0.10 lbs

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